

Date: Wednesday, 26/11/2008 12:41:49 PM
 User: Jodie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HYDRAULIC CYLINDER
Job Number	: 43733		
Estimate Number	: 12750		
P.O. Number	:	Part Number	: 41232 200 007 001
This Issue	: 26/11/2008 S.O. No. :	Drawing Number	: 41232-200-007 REV IR
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: IR
Previous Run	: 42266	Material	:
Written By	:	Due Date	: 10/12/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 08.11.26</u>		
Comment	: Est Rev:A New Issue 07-02-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	7D 1 H	Clippard Brass Cylinder
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Spring (Step Actuator)

2.0	PG	PURCHASING
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Comment: PURCHASING
 Issue P/O: 7692
 Possible Supplier: Wainbee
 Material release note is required

C208111/27

(10)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

P 8/12/16 (10)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/03/24 (10)

5.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING
 Mask threaded ends and threaded holes.
 1-Apply polyimide primer
 Batch: _____
 2-Apply polyurathane coating gloss black
 Batch: _____

N/A
S 2/3/24
 See Attached E-mail

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____






Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:41:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HYDRAULIC CYLINDER	
Job Number: 43733		Part Number: 41232 200 007 001	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
Note: Paint Nut on threaded end and leave attached to assembly			
6.0	QC14	INSPECT SPRAY PAINT	
Comment: Inspect Spray Paint		<i>See Attached E-mail</i>	
7.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Install Decal then <i>331 780 \$X</i> Identify and Stock Location: _____ <i>09/03/25 (10)</i>			
8.0	QC21	FINAL INSPECTION/W/O RELEASE	
Comment: FINAL INSPECTION/W/O RELEASE			
Job Completion		 <i>mf 09-03-25</i>	

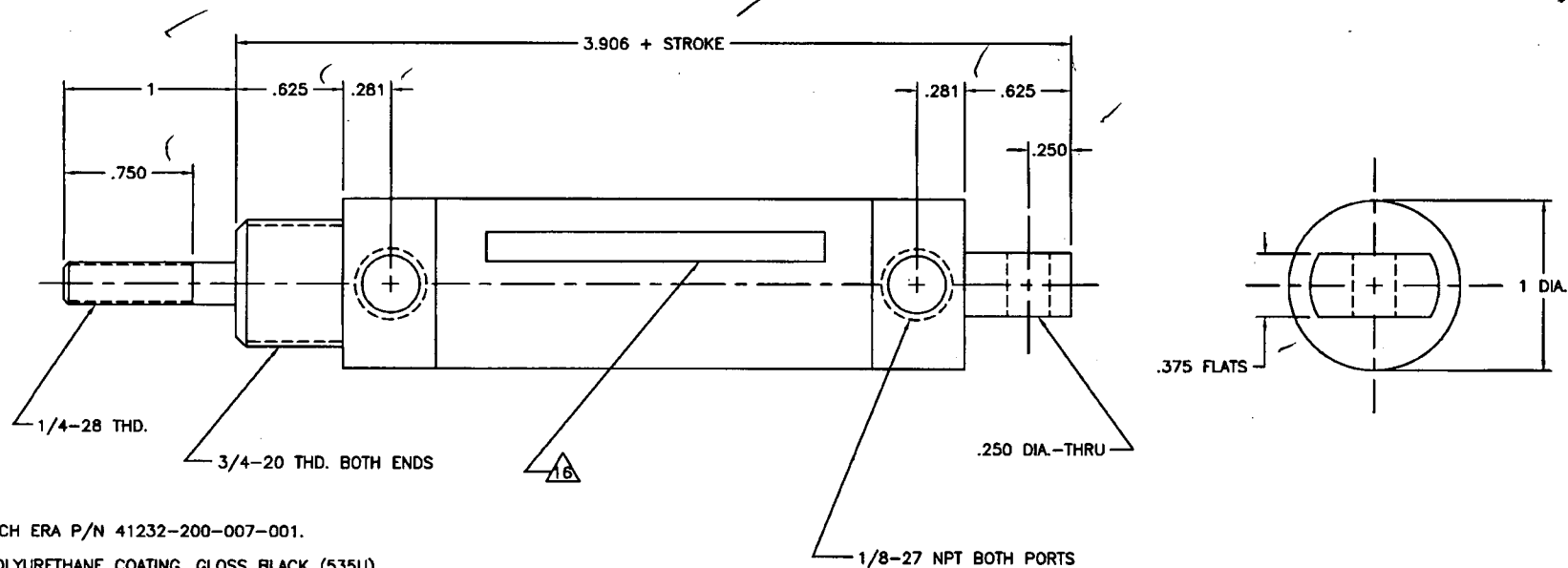
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



16 VIBRO ETCH ERA P/N 41232-200-007-001.

15. APPLY POLYURETHANE COATING, GLOSS BLACK (535U) IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4009.

14. APPLY POLYIMIDE PRIMER IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4004.

13. PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

NOTE - ALTER 7D1H ASSY IN ACCORDANCE WITH INSTRUCTIONS LISTED ABOVE.

12. SINTERED BRONZE ROD BUSHING.

11. ROD DIAMETER: 0.25 INCHES.

10. PORTS: 1/8 NPT.

9. POWER FACTOR: 0.6 SQ. IN.

8. STROKE: 1.000 INCH.

7. ACTION: DOUBLE ACTING.

6. MOUNT: UNIVERSAL MOUNT.

5. TEMPERATURE RANGE: 30° F TO 250° F

4. 7D1H CONFIGURED WITH HYD. FLUID.

3. ROD: ROTATING.

2. BORE: 0.875 INCHES.

1. HEAVY DUTY BRASS CYLINDERS.

NOTES:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 41232-200-007-001
WATER ORDER 41232-200-007-001

-001 BRASS CYLINDER

-001		BRASS CYLINDER 7D1H		CLIPPARD INSTRUMENT LABORATORY, INC., CINCINNATI, OH.	
PART NO.		NAME		STOCK SIZE	MATERIAL
NO. REQ'D PER ASSY		LIST OF MATERIAL		MATL.SPEC	ZONE
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED		DESIGN	D. NELSON 3/14/03
THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. AND DISCLOSURE, REPRODUCTION OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		X ± .1		CHECK	D. MURPHY 3/14/03
		XX ± .03		STRESS	
		XXX ± .010		PROJ. ENGR.	
		ANGLES ± 1/2°		DWG. SIZE	C
				SCALE	NONE
				HEAT TREAT	
				FINISH	
-001 2 41232-000-001		NEXT ASSEMBLY		TITLE HYDRAULIC CYLINDER (ALTERED ITEM DRAWING)	
				DWG. NO. 41232-200-007	
				REV. IR	

Era Aviation, Inc.





WAINBEE LIMITED
215 BOUL BRUNSWICK
POINTE CLAIRE, QC H9R 4R7
Phone: 514-697-8810 Fax: 514-697-3070

Packing List

CUSTOMER P/O NUMBER	
:00007692	
RELEASE #	11205297-1
DATE	12/15/08 15:52:53

127404
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
613-632-3336

SHIP TO
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

ORDER NUMBER 11205297	ORDER DATE 12/02/08	SHIP DATE 12/15/08	WRITTEN BY Marie Robinson		CONTACT CHANTAL LAVOIE		
CUSTOMER P/O NUMBER :00007692							
JOB # F							
RELEASE #							
PRODUCT / DESCRIPTION			QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE /EXTENSION
7D-1-H			10	EA	10	0	126.200
CLIPPARD BRASS CYLINDER							1262.00

Wainbee's Standard Terms and Conditions Apply

Returned Goods Not Accepted Without Prior Authorization.

Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.

L Lacelle

From: L Lacelle [llacelle@dartaero.com]
Sent: March 24, 2009 6:55 AM
To: 'David Shepherd'; 'Mike Petsche'
Cc: 'Jason Murdoch'; 'David Duval'
Subject: RE: Actuator Paint

Will the drwg and estimates be updated?
Thx
LL

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: March 23, 2009 5:29 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: Actuator Paint

Jason,

As we discussed, it is acceptable to leave the p/n 41232-200-001-001/-002 Actuators unpainted. From inspecting the parts, there appears to be adequate protection already. Parts are already anodized, CAD plated, or manufactured from stainless steel.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Monday, March 23, 2009 2:30 PM
To: 'David Shepherd'
Subject:

Please don't forget my e-mail for the hydraulic cylinders to remove the paint. Thanks and have a good flight back.....ass wad!!!!!!

Jason Murdoch

Qc. Coordinator

jmurdoch@dartaero.com

No virus found in this incoming message.
Checked by AVG.
Version: 7.5.557 / Virus Database: 270.11.24/2018 - Release Date: 3/23/2009 6:52 AM

No virus found in this outgoing message.
Checked by AVG.
Version: 7.5.557 / Virus Database: 270.11.24/2018 - Release Date: 3/23/2009 6:52 AM

24/03/2009